

Work Order ID: 52412

September 23, 2009 1:52:14 PM

Page 1

Item ID: D206-642-541

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

CL - MF

Date: 09/09/24 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D206-642

Rev M

100

DC

0.00

0.00

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	Skidtubes	0.00	0.00							
	Skidtubes										
	Memo	1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274.									
		2- remove fwd indexing ridge as per dwg D3274. Prepare for welding									
		3- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: <u>H109213</u>									
		4- grind fwd cap weld on top surface only									
		5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.									
		6-Drill Aft cap pilot hole using DT8025									
		7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274									
		8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #									
		9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.									

DP 9-9-29

AWM 9-9-29
PD 09.09.30

9-10-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 10/08/09 **Req'd Qty:** 1.00

Customer ID:

Customer Name:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Hours

[illegible]

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Plan:

Date:

Tooling:

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QC:

Date:

SPC (Y/N):

Date:

[illegible]

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Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID	Work Center ID	Operation Description	Hours		Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			Set Up	Run							
170	Skidtubes	Skidtubes	0.00	0.00							
		Memo									
		1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.									
		2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Debur									
		3-DRILL TOE PIN HOLE .640" DIA AS PER DWG. USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES									
		4- Countersink crossbolt spacer holes as per Dwg D3274									
		5- prepare for welding									
180	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00							
	Quality Control										

Memo

Az 3.004
L² 24.5*

DP 9-10-14

BE 09-10-15

2) 8076015

(40) f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer ID:**Customer Name:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Skidtubes		0.00	0.00							
	Skidtubes	Skidtubes									
	Memo	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/R: Aluminum Rod M109213 BE 09/10/15									
		3-Grind cross bolt welds flush as per Dwg D3274. _____ AWM 9-10-21									
		4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr. _____ AWM 9-10-22									
200	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00							
	Quality Control										
	Memo										
210	QC	QC10- Inspect visual per QSI004- ground welds	0.00	0.00							
	Quality Control										
	Memo										
220	HandFinish	Pressure Wash per QSI005 4.3	0.00	0.00							
	Hand Finishing										
	Memo	-7M 09/10/22 (X1) Ø									

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Reference:

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Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:**Required Date:** 10/08/09**Req'd Qty: 1.00****Customer ID:****Customer Name:**

Approvals: **Process Plan:**

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M112260 => H1 09/10/22</i> Memo START TIME: <u>1:30pm</u> OVEN TEMPERATURE: <u>320°C</u> FINISH TIME: <u>2:00pm</u>	0.00	0.00				X-1	Ø		
240	QC Quality Control	QC3- Inspect Part Finish Memo	0.00	0.00				X1			
250	HandFinish Hand Finishing	HandFinishing Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/RUN/A□LPS-3□ <u>A/H</u> 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/RUN/Sikaflex-291 □ <u>M112391</u> Sikaflex expire date: □ <u>10/20</u>	0.00	0.00				X1			
260	QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Nut Plate & Inserts	0.00	0.00				X-1	Ø		

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Item ID: D206-642-541

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Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	HandFinish	HAND FINISHING RESOURCE #1	0.00	0.00				X1			
	Hand Finishing	Memo									
		1-Install wearpads & gaskets as per Dwg D3274.									
		2-Install ring as per Dwg D3274									
		A/R[][]Sikaflex-291 [] m1122911									
		Sikaflex expire date: 10/20									
		3-Inspect for foreign objects as per QSI 024									
		4-Spray inside of tube on both sides of web with LPS-3									
		A/R LPS-3 Batch: 1/1									
		5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.									
		A/R[][]Sikaflex-291 [] m1123011									
		Sikaflex expire date: 10/20									
		LPS PROCPN Batch: m104251									
280	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00							
	Quality Control	Memo									
290	Packaging	Identify as per dwg & Stock Location: _____	0.00	0.00							
	Packaging	Memo									

MP 09/10/26

2) 809/10/27

APP 52086 9/10/28 @ 54

Work Order ID 52412

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Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC	QC21- Final Inspection - Work Order Release	0.00	0.00							
	Quality Control										

Memo

09/10/28 JH
Bl 0910-28

Picklist Print

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Page 1

Work Order ID: 52412

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-1-190RevD1		Manufactured	No			110	Each	74.0000	1.0000			
												
Extrusion Round 3" 206												

99-29

D3285-1RevA

Manufactured No



Cap

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	74	
47575	74	

1

D3282-041RevC

Manufactured No



Float Web (206L/407)

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	34	
47635	34	

1 PD 09.09.30

9-10-7

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
LG	10	
48389	10	

1

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 52412



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			190	Each	711.0000	4.0000			
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 83

51529 83

Main Warehouse

ST 628

36013 5

47112 383

48271 240

D3275-1RevA1 Manufactured No

190 Each 100.0000 12.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 100

47464 1

48117 43

48270 56

1240

12 BE 09/10/15

12 BE 09/10/15

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Work Order ID: 52412

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3212-4-03		Purchased	No			250	Each	314.0000	2.0000			
												
Cherry Rivet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

314

111359

96

112314

200

35984

18

D3415-041RevB

Manufactured

No

250

Each

95.0000

1.0000



Nut Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

95

33842

95

CCR264SS3-3

Purchased

No

250

Each

271.0000

2.0000



Cherry Rivet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

271

11548

56

111827

115

112314

100

X2 MO 09/10/23

X1 MO 09/10/23

X2 MO 09/10/23

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			250	Each	5,439.000	78.0000			



Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

110511

5439

5439

270

Each

43.0000

1.0000

D3536-15RevA

Manufactured

No



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

47711

48159

51600

43

5

12

26

x78 mo 09/10/23

x1 mo 09/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-23RevA		Manufactured	No			270	Each	32.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 12

51609 12

Main Warehouse

ST 20

30754 1

47713 19

D3536-35RevA

Manufactured No

270

Each

41.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 41

48160 15

51628 26

XI mo 09/10/26

XI mo 09/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3536-39RevA		Manufactured	No			270	Each	30.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

12

51637

12

Main Warehouse

ST

18

44648

1

47714

6

48161

11

XI

MD 09/10/26

D3535-15RevB

Manufactured No

270

Each

15.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

15

30750

4

42233

1

48155

10

XI

MD 09/10/26

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D3535-35RevB		Manufactured	No			270	Each	12.0000	1.0000			



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

12

48157

12

D3535-39RevB

Manufactured

No

270

Each

15.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

15

47525

2

48158

13

D3535-23RevB

Manufactured

No

270

Each

13.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

13

48156

13

XI mb 09/10/09

XI mb 09/10/09

XI mb 09/10/09

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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September 23, 2009 1:51:55 PM

Work Order ID: 52412

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-3RevC		Manufactured	No			270	Each	72.0000	1.0000			
												
Wearpad												

Warehouse Loc Qty Loc Code
Location



Main Warehouse

ST 72

30758 8

33881 17

35697 47

D3537-1RevC		Manufactured	No			270	Each	192.0000	9.0000			
												
Wearpad												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 30

48288 2

50321 28

Main Warehouse

FP17 162

51678 162

51624

XI MD 09/10/26

X9 MD 09/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:52:02 PM

Page 9

Work Order ID: 52412

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C10L

Purchased

No

270

Each

6,864.000

80.0000



washer

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

6764

112116

1764

102612

5000

AN960C416

Purchased

No

270

Each

706.0000

1.0000



washer

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

706

100993

706

X 80 mo 09/10/26

X 1 mo 09/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:52:02 PM

Page 10

Work Order ID: 52412

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB		Manufactured	No			270	Each	1,186.000	2.0000			



Phenolic Washer



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 686

39275 19

42329 121

47628 546

Main Warehouse

ST117 500

51674 500

12 MD 09/10/26

AN3C4A

Purchased

No

270

Each

1,976.000

80.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1976

112082 14

112314 140

112612 146

112720 1176

112724 500

12794

180 MD 09/10/26

September 23, 2009 1:52:02 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:52:08 PM

Work Order ID: 52412

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4C5A  BOLT		Purchased	No			270	Each	603.0000	1.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	603	
104936	19	
<u>110552</u>	82	
112243	500	
18918	2	

xl MD 09/10/20

D2646RevC

Manufactured No

270 Each 56.0000 1.0000



Aft Cap

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	56	
20208	0	
43801	1	
46327	6	
<u>48109</u>	49	

xl MD 09/10/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

September 23, 2009 1:52:08 PM

Work Order ID: 52412

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3413-1RevA		Manufactured	No			270	Each	22.0000	1.0000			



Ring



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

22

48123

22

X1

MD 09/10/09

September 23, 2009 1:52:08 PM

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Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

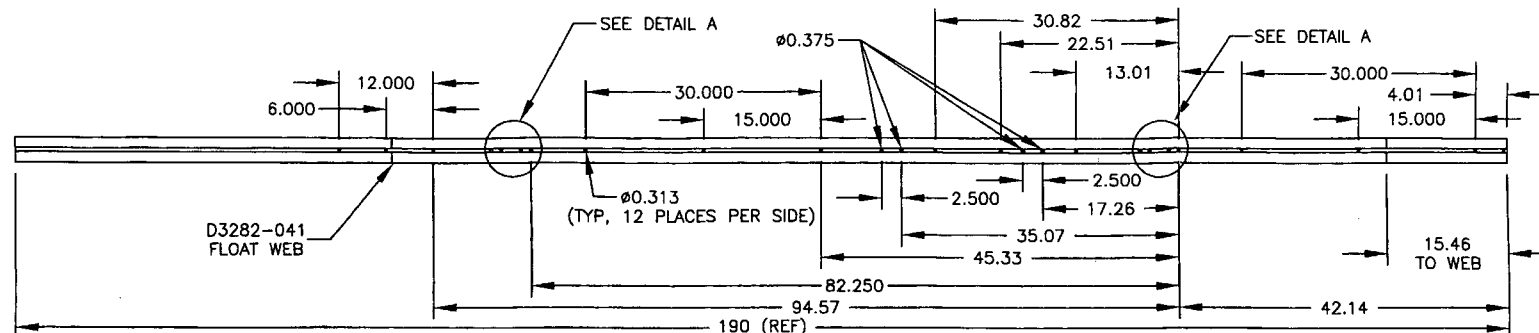
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

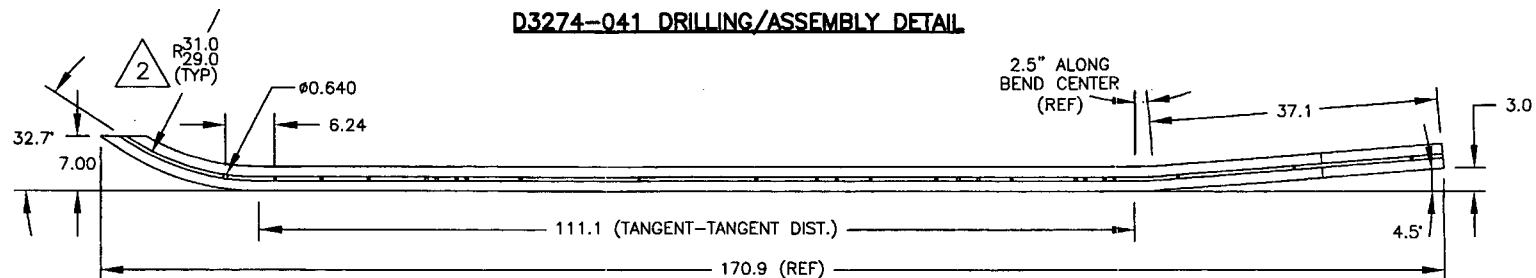
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date, & initial all entries

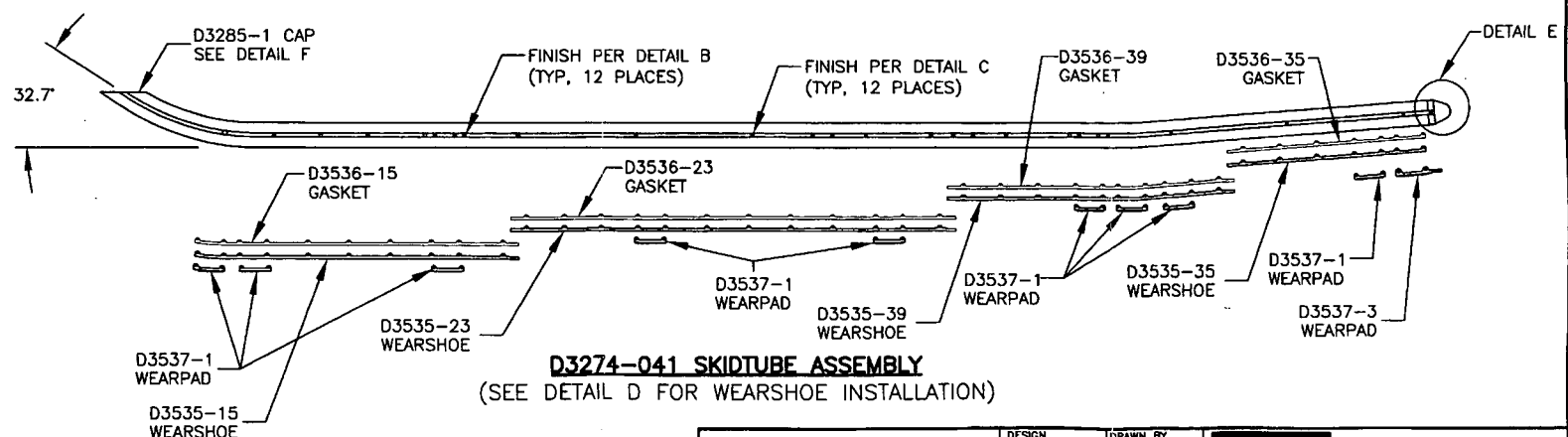
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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		CHECKED	APPROVED	D3274	SHEET 2 OF 4
		DATE		TITLE	SCALE
		06.12.19		SKIDTUBE ASSEMBLY	1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

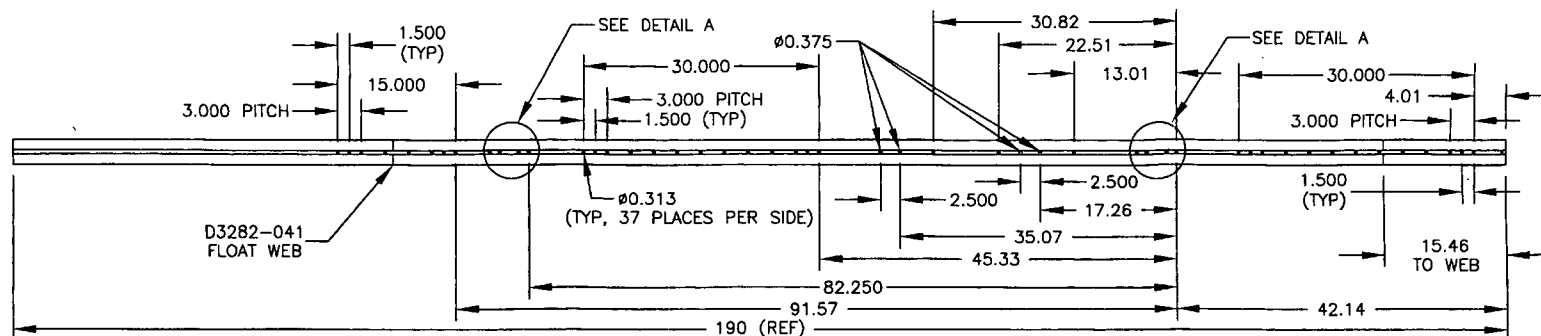
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

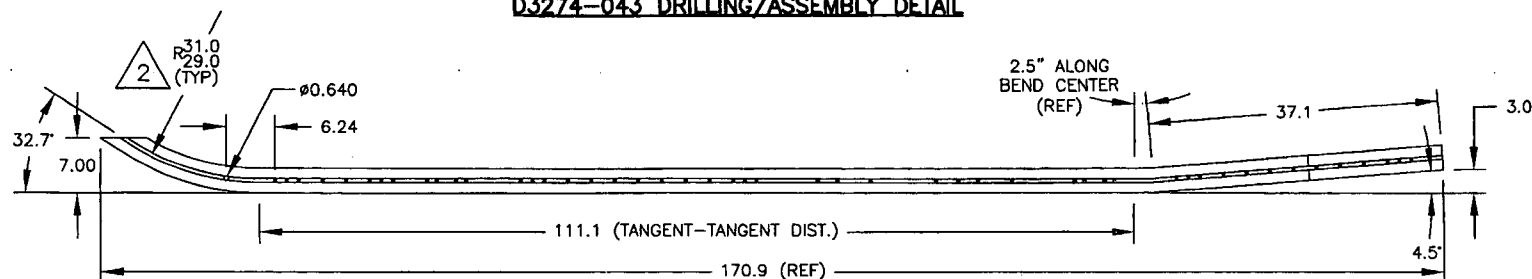
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

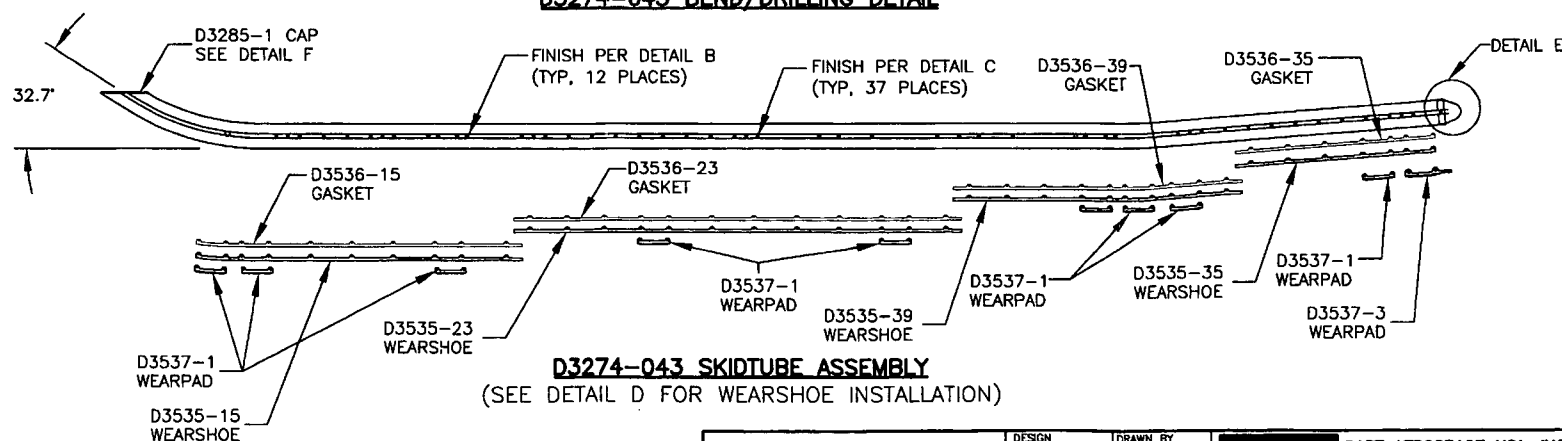
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE	TITLE	D3274	SHEET 3 OF 4
06.12.19	SKIDTUBE ASSEMBLY		SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

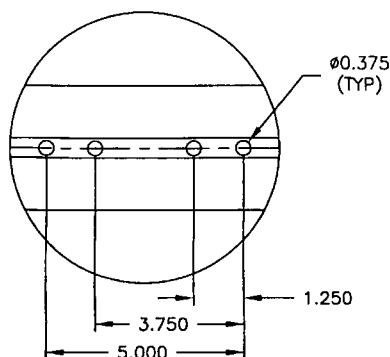
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

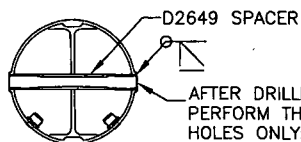
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

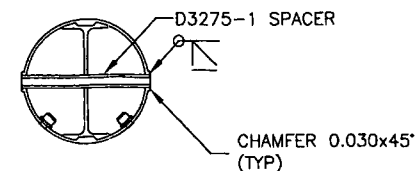


DETAIL B FOR 0.375 HOLES ONLY

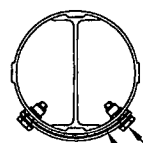


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY

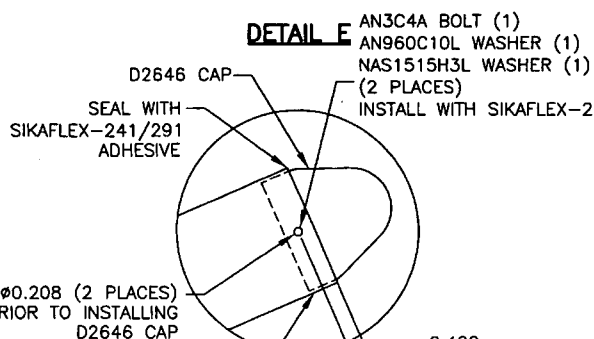


DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

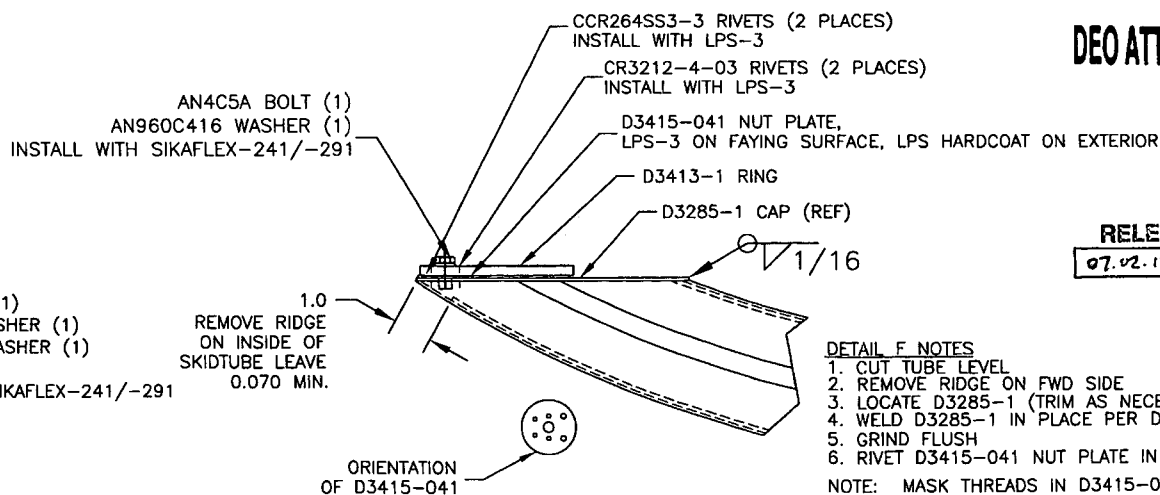
DETAIL E



0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED
07.02.12

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CHECKED	APPROVED	CP	PH	DRAWING NO.	REV. D
DATE	06.12.19	D3274		SHEET 4 OF 4	SCALE
TITLE				SKIDTUBE ASSEMBLY	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

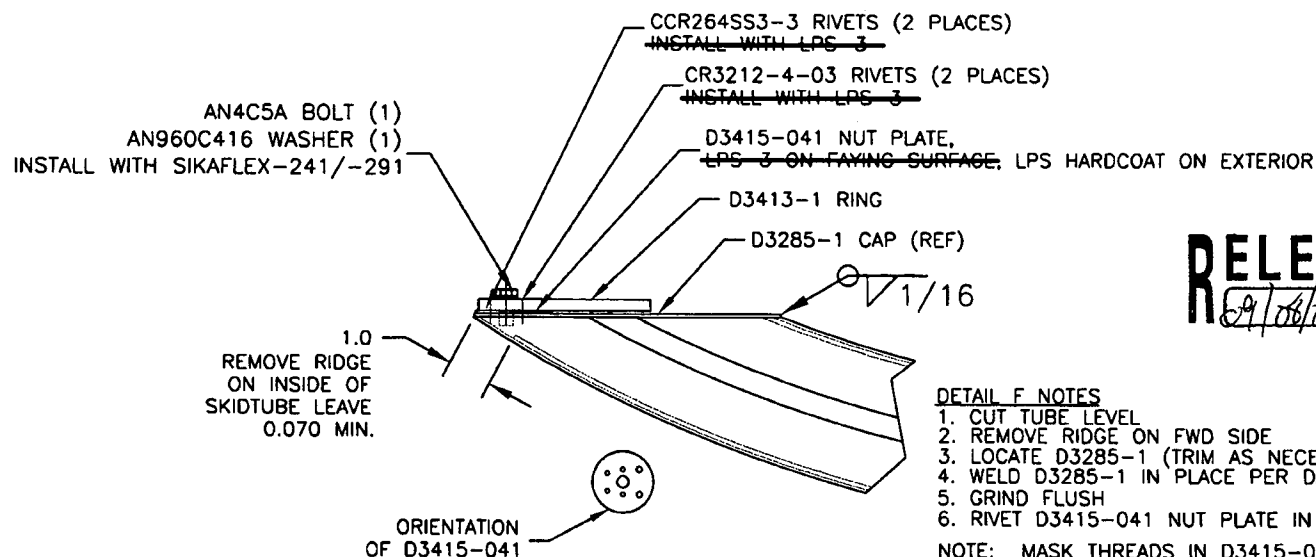
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 211

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52411
Part number: D206-642-541
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Pct. Paul Date of Test Coupon 09-10-09
Welder Barclay Elliott Date of Test Coupon 09-10-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld